

Date: Tuesday, 3/20/2007 12:04:27 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW CAP
Job Number	: 31346		
Estimate Number	: 10483		
P.O. Number	: <u>NIA</u>	Part Number	: D3401041
This Issue	: 3/20/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D3401 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NA</u> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 29214	Material	: <u>NIA</u>
Written By	:	Due Date	: 4/10/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>AP 07.03.20</u>		
Comment	: Est. A 06/09/01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6R3500	Inventory
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Comment: Qty.: 0.3675 f(s)/Unit Total : 7.3500 f(s)

Inventory

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6R3.500)

Batch: M100720

MS 07/03/28

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks

MS 07/03/28 20

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA532 & Dwg D3401

Folio Rev: AA

Dwg Rev: B

Deburr

MS 07/03/28 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS / 07/03/28 20

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: B

Folio Rev: B

Identify as D3401-1

Deburr & Buff rad as per Dwg D3401

SG 07.03.31 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:04:27 PM
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Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

me 07/03/31 20

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

FF 07-04-03

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jaquos

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-d 07/04/04

20x

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m103706

FF 07/04/04 (20)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-d 07/04/12

20x

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Insert

Pick:

Qty Part number

Description

Batch

4 NAS1330C3KB116 Insert

Assemble as per Dwg D3401

Identify as D3401-041

- M101396 (X88) (20)
- M102018 (22)
HL 07-04-12

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 27/04/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Finishing*

95 07-04-12 (20)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07-04-13

Job Completion



07-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

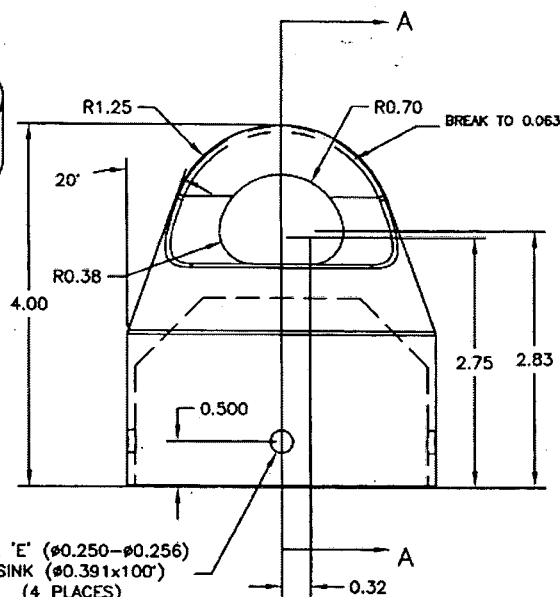
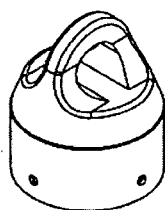
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

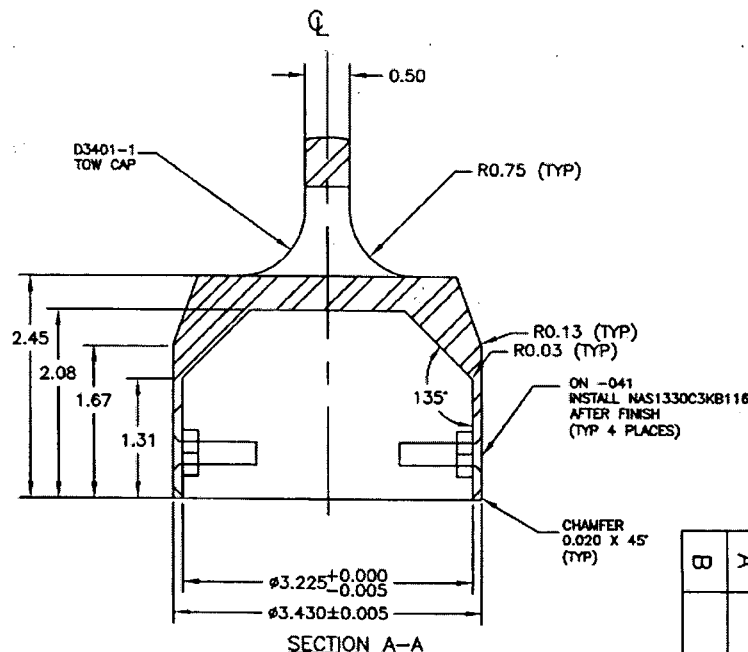
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 ø3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31344

RELEASED
05-08-09

DESIGN	DRAWN BY	DATE	TITLE	SCALE
PH	PH	05.06.09	TOW CAP	1:2
CHECKED	APPROVED	05.02.24	NEW ISSUE	
		05.06.09	CHAMFER INSIDE, REMOVE RADIUS	

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. B
SHEET 1 OF 1